

Date: Thursday, 2/23/2006 10:24:39 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 25934		
Estimate Number	: 11376		
P.O. Number	: N/A	Part Number	: D33872
This Issue	: 2/23/2006 S.O. No. : N/A	Drawing Number	: D3387 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/22/2006 Qty: 8 Um: Each
Checked & Approved By	: <u>06.02.23</u>		
Comment	: Est:A 05.06.10 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5680 f(s)/Unit Total: 12.5437 f(s)
6061-T6 Bar .50" x 6.0"
Material: 6061-T6/T651 (QQ-A-200/8)
(M6061T6B0.500x06.000)
Identify for D3387-2
Batch: M100046

SAD 06:03:05

8

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank: 6.000" x 0.500" x 17.800" long

SAD 06:03:05

8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA512 and Dwg D3387
Identify as D3387-2
C'sink Ø0.375" as per Dwg D3387
Tumble and Deburr NO sharp edges

SAD 06:03:09

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:03:09

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 26/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 25934

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/03/10 8

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rec'd 3/14 8 Packch

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/15 8

Job Completion



u 06.03.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25934
Description: Arm		Part Number:	D3387-2
Inspection Dwg: D3387 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.502	—			
7.577	+/-0.010	7.570	—			
R0.030	+/-0.010	R0.030	—			
Ø0.191	+0.005/-0.000	Ø0.191	—			
1.700	+/-0.010	1.701	—			
0.188	+/-0.010	0.187	—			
11.405	+/-0.010	11.408	—			
Ø0.507	+0.000/-0.001	Ø0.5068	—			
2.033	+/-0.005	2.035	—			
R0.300	+/-0.010	R0.300	—			
1.000	+/-0.005	1.000	—			
2.000	+/-0.010	2.001	—			
1.347	+/-0.005	1.348	—			
0.250	+/-0.010	0.241	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.133	—			
R0.032	+/-0.010	R0.032	—			
Ø0.375 x100°	+/-0.010	Ø0.373x100°	—			
0.500	+/-0.010	0.494	—			
0.300	+/-0.010	0.298	—			

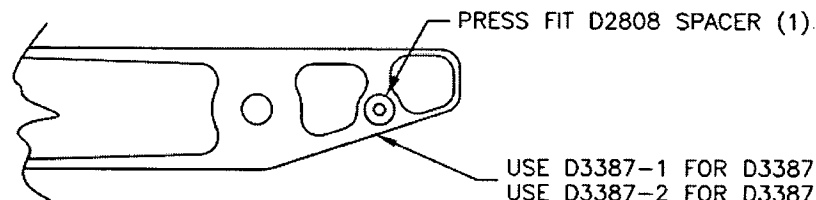
Measured by:	cmf	Audited by:	MS	Prototype Approval:	N/A
Date:	06/03/09	Date:	06/03/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	P/O D3387-042	KJ/JLM



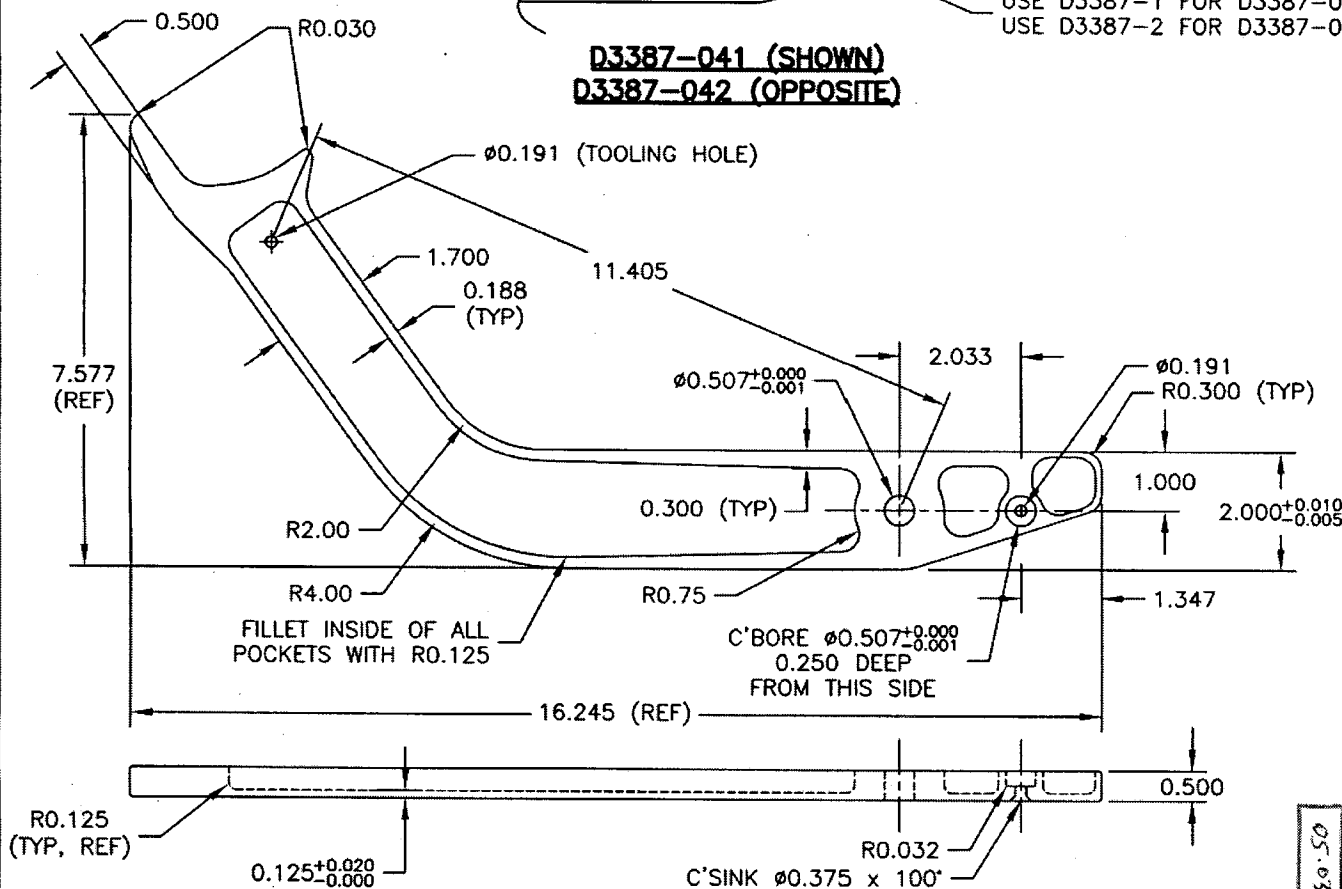
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.01.18	DRAWING NO. D3387	REV. A
	TITLE ARM	SHEET 1 OF 1
A	05.01.18	SCALE 1:3
	NEW ISSUE	

RELEASED
05.03.11



USE D3387-1 FOR D3387-041
USE D3387-2 FOR D3387-042

D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

MACHINE PER DRAWING FILE "D3387-A.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK
(REF DART SPEC. M6061T6B0.500)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 25934